



Dart Aerospace Ltd.
1270 Aberdeen St
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D2360**Job Sheet 192936**

13 Feb
12 9ml

Part No: D2360**Job Qty:** 6 pcs**Part Name:** Litter Tie Down Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/4/19**Job Tracking No:****Due Date:** 5/15/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		5/15/19	0.00	0.20	Bandsaw - 1		mm L 19/06/07
110	HAAS 4 Axis - B4B	6 pcs		5/15/19	0.26	8.96	HAAS - 1 - B4B		mm L 19/06/07
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs		5/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mm L 14/06/07
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		

**Container No:** S188599**Part:** D2360**Job No:** 192936**Serial No/Batch:** S188599**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 06/07/19

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130 QC 8	6 pcs	5/15/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	5.19-06-11
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	5/15/19	0.00 0.47	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	5.19 JUN 12 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 -	

				B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White Gl(A)- B4B	6 pcs	5/15/19	0.00 0.36	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	6 pcs	5/15/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
170 Small Fab - 2 - B4B	6 pcs	5/15/19	0.00 1.89	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
180 QC 5	6 pcs	5/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Packaging 3-1 - Stock - B4B	6 pcs	5/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	

BK 19-6-12

START: 1:55 OUT: 2:00 FINISH: 2:25

DAS 58 JUN 21 2019 9-89

DAS 40 JUN 25 2019 9-89

DAS 28 9-89

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200	QC 21 - SA	6	5/15/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53
					DAS
					JUN 26 2019 70
					9-89
Part Op 100 - (Bandsaw) Cut blanks: 12.65" Long Descriptions: 110 - (HAAS CNC vertical machine #1) 1-Machine as per Folio D2341 and Dwg D2341 2-Deburr 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Small Fab) Assemble as per dwg D2360 180 - (QC5- Inspect part completeness to step on W/O) 190 - (Identify as per dwg & Stock Location: _____) 200 - (QC21- Final Inspection - Work Order Release)					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	6.3240 ft (1.054 ea)	100-Bandsaw - 1	5173848 =
AN526C1032R18	Screw	6 Ea (1 ea)	170-Small Fab - 2 - B4B	F4523
D2002-015	Knob	12 pcs (2 ea)	170-Small Fab - 2 - B4B	5178005 5142908
D2345	Lock Channel	6 pcs (1 ea)	170-Small Fab - 2 - B4B	5172992
D2366	Lock Handle	12 pcs (2 ea) 5190051	170-Small Fab - 2 - B4B	5098009 5141478
D2367	Handle Knob	6 pcs (1 ea)	170-Small Fab - 2 - B4B	5041512 5162094
D2372	Quick Release	12 pcs (2 ea) 5176328	170-Small Fab - 2 - B4B	5176327 x7 5189101
D2373	Spring	6 pcs (1 ea) 5191472	170-Small Fab - 2 - B4B	5161152
D2444	Pip Pin Assembly	6 pcs (1 ea)	170-Small Fab - 2 - B4B	5176328 x5 5160351
MS20470AD3-4	Rivet, Universal Head	6 Ea (1 ea)	170-Small Fab - 2 - B4B	5161368SI-1
MS21042L3	Nut	18 Ea (3 ea)	170-Small Fab - 2 - B4B	5166712
MS27039-1-13	Screw	6 Ea (1 ea)	170-Small Fab - 2 - B4B	50711833
MS27039-1-15	Screw	12 Ea (2 ea)	170-Small Fab - 2 - B4B	5114920
NAS1149D0332J	Washer	48 Ea (8 ea)	170-Small Fab - 2 - B4B	5156765
NAS1149D0363J	Washer	12 Ea (2 ea)	170-Small Fab - 2 - B4B	5162884
NAS679A3W	Nut	6 Ea (1 ea)	170-Small Fab - 2 - B4B	5172992 5131225

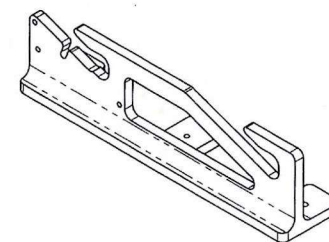
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	6	12	0
170-Small Fab - 2 - B4B	AN526C1032R18	6	86	0
	D2002-015	12	8	0
	D2345	6	5	0
	D2366	12	19	0
	D2367	6	28	0
	D2372	12	5	0
	D2373	6	18	0
	D2444	6	7	0
	MS20470AD3-4	6	5,715	0
	MS21042L3	18	3,786	0
	MS27039-1-13	6	393	0
	MS27039-1-15	12	332	0
	NAS1149D0332J	48	3,628	0
	NAS1149D0363J	12	1,610	0
	NAS679A3W	6	38	0

Part Specifications

Specifications could not be found.

Plex 4/4/19 10:10 AM Dart.lajeunesse.marie



- 1) MATERIAL: MAKE FROM D6201-125 EXTRUSION
REF. 6061-T6/T651 PER QQ-A-200/8
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2341" AND B/N "BXXXXXX" ON BOTTOM FACE PER QSI 044 6.1
- 7) WEIGHT: 1.64 lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. 0
MFG. APPR.	JLM	D2341	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LITTER TIE DOWN BRACKET (LOCKING)	
DATE	15.11.12	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT OR ANY PART THEREOF IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMINGLED TO ANY OTHER PERSON WITHOUT	

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